

Work Order ID 64223

Tuesday, November 30, 2010 12:37:42 PM



Page 1

Item ID: D3829-3KIV

Accept



Setup Start



Revision ID:

Stop



Item Name: Vertical Tunnel, Aft Center

Start Date: 11/30/2010 Start Qty: 3.00



Cust Item ID:

Required Date: 12/14/2010 Req'd Qty: 3.00



Customer:

Reference:

Run Start

Approvals: Process Plan: *V*

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3829

A

100

0.00



HandThermo

Memo

0.00

Hand Finishing Thermoforming

I-Cut Sheet to required Blank size

*x3**Wlc 10/17/16*

105

0.00



HandThermo

Memo

0.00

Hand Finishing Thermoforming

Dry Sheet as per QSI022 KYDEX

Temp: *150*Time IN: *4:30 10/12/15*Time OUT: *7:00 10/12/16**BB 10/12/16*

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	64223
Description: VERTICAL TUNNEL AIR CENTER		Part Number:	D3829-3 KIV
Inspection Dwg: D3829 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST
THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching				

Measured by: BB	Date: 10/12/20
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TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
37.0	REF	37	✓			
8.2	REF	8.25	✓			
.5	TYP	.51	✓			
.050	Min	.078	✓			

Measured by: BB	Date: 10/12/20
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Audited by: 8	Date: 4/6/16
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Preliminary Approval:	Date:
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Rev	Date	Change	Revised by	Approved
B	10.04.14	Added preliminary approval	KJ	

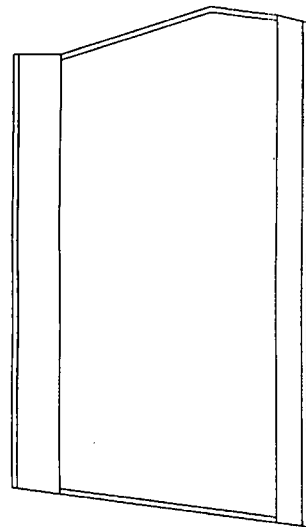
10.04.14

8 7 6 5 4 3 2 1

D

C

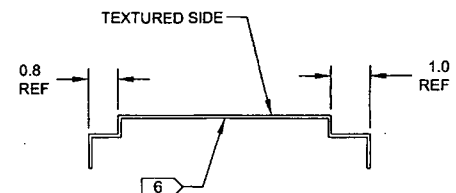
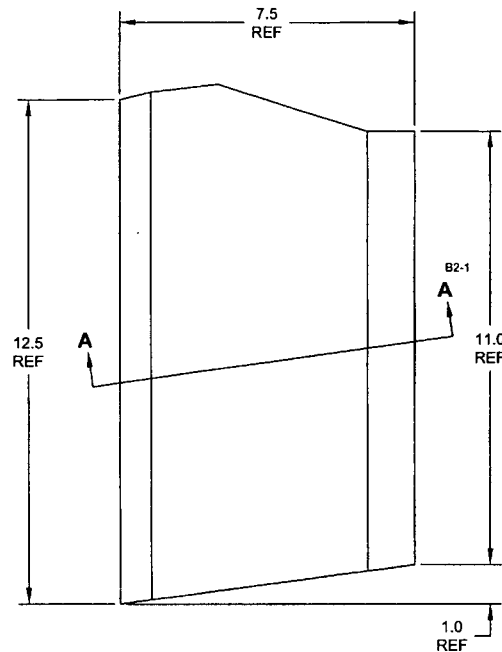
B



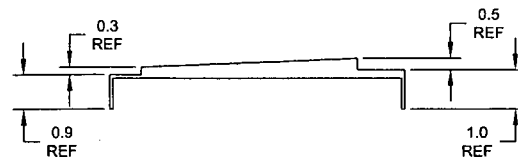
MIN THICKNESS
0.035
(BOTH SIDES)

1.5
REF

0.5
REF



SECTION A-A



D3829-1 VERTICAL TUNNEL, UPPER L/H

NOTES:

- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: DART P/N (SEE TABLE) PER DART QSI 044 6.4
- 7) WEIGHT: 0.35 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9232 PER DART QSI 022. TRIM PER MOLD.
- 9) MINIMUM THICKNESS: 0.050" UNLESS OTHERWISE NOTED

PART NUMBER	DESCRIPTION
D3829-1KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3829-1KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

A	NEW ISSUE	SC	10.10.21
REV.	DESCRIPTION	BY	DATE
DESIGN	SC		
DRAWN	SC		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.10.21		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. REV. A
D3829 SHEET 1 OF 3
TITLE SCALE
VERTICAL TUNNEL (BELL 206 L/L1) NTS

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2010-10-24

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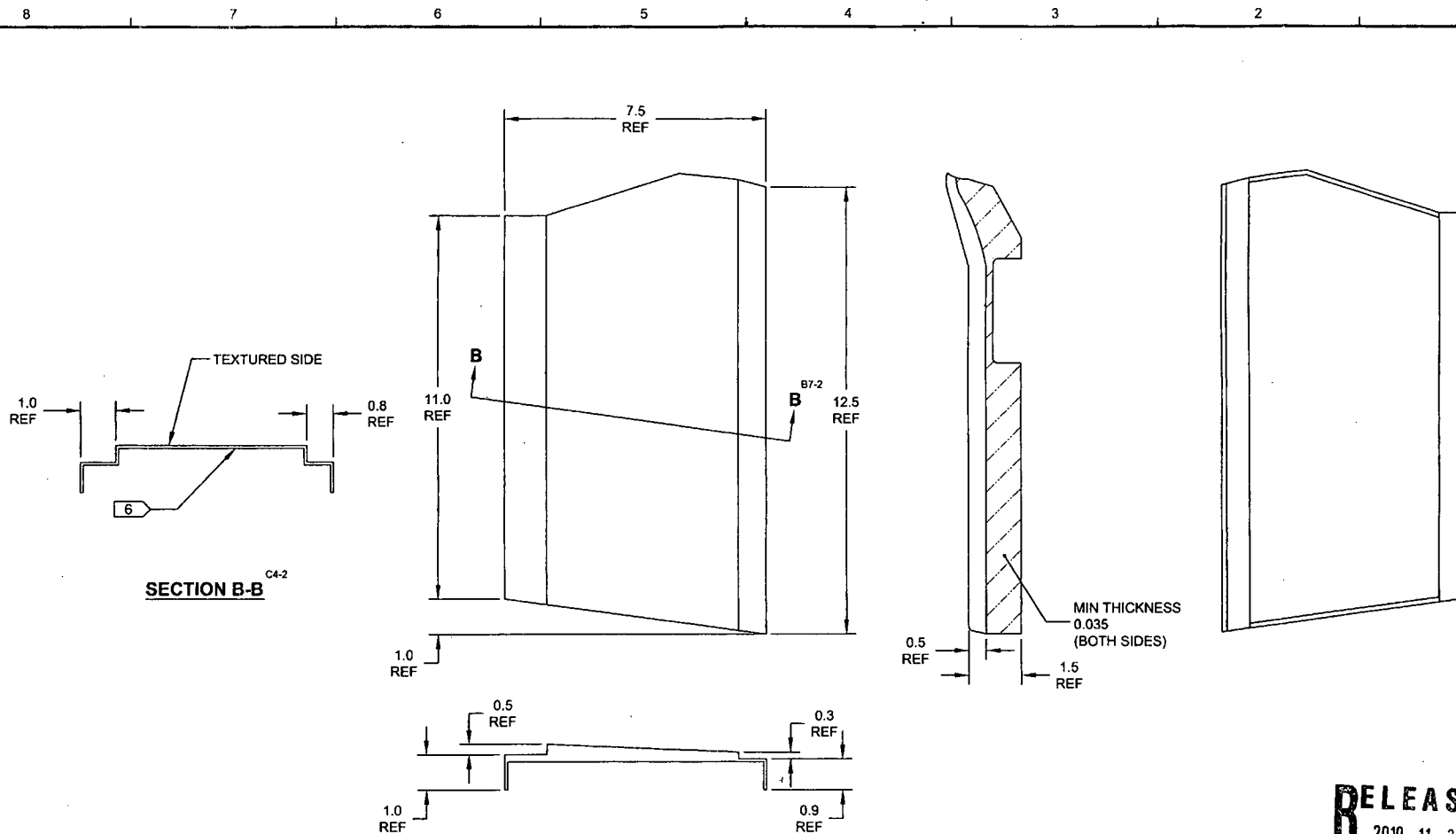
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3829-2 VERTICAL TUNNEL, UPPER R/H

NOTES:

- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: DART P/N (SEE TABLE) PER DART QSI 044 6.4
- 7) WEIGHT: 0.35 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9233 PER DART QSI 022. TRIM PER MOLD.
- 9) MINIMUM THICKNESS: 0.050" UNLESS OTHERWISE NOTED

PART NUMBER	DESCRIPTION
D3829-2KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3829-2KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

DESIGN	SC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3829	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		VERTICAL TUNNEL (BELL 206 L/L1)	NTS
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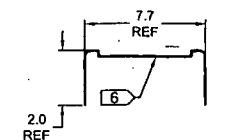
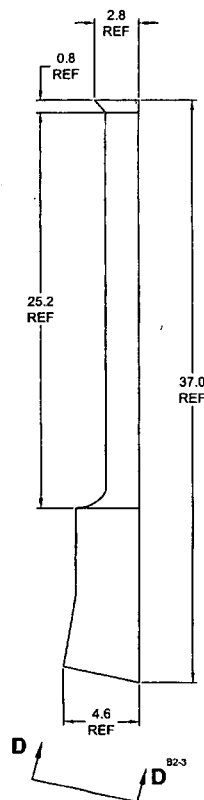
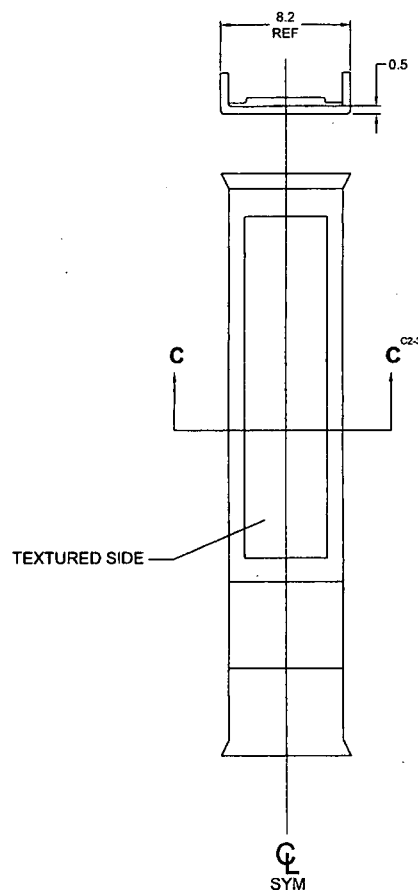
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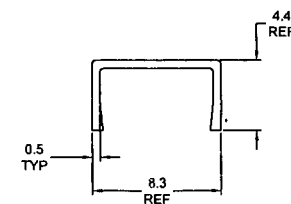
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



SECTION C-C



VIEW D-D

RELEASED
2010-11-24

D3829-3 VERTICAL TUNNEL, AFT CENTER

NOTES:

- 1) MATERIAL: SEE TABLE
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: DART P/N (SEE TABLE) PER DART QSI 044 6.4
- 7) WEIGHT: 1.2 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9226 PER DART QSI 022. TRIM PER MOLD.
- 9) MINIMUM THICKNESS: 0.050" UNLESS OTHERWISE NOTED

PART NUMBER	DESCRIPTION
D3829-3KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3829-3KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

DESIGN	SC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3829	SHEET 3 OF 3
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NOTE: Date & initial all entries

Daryl Leger

From: David Shepherd [dshepherd@dartaero.com]
Sent: Tuesday, January 04, 2011 4:46 PM
To: 'Marc Bellavance'
Cc: 'Leger, Daryl'; 'Downing, Eric'; 'Murdoch, Jason'
Subject: RE: D3829-3 Vertical Tunnel Pannel

Marc,

As discussed, I recommend option 3.

David

From: Marc Bellavance [mailto:mbellavance@dartaero.com]
Sent: Tuesday, January 04, 2011 8:21 AM
To: Shepherd, David
Cc: Leger, Daryl; Downing, Eric; Murdoch, Jason
Subject: D3829-3 Vertical Tunnel Pannel
Importance: High

Morning David,

Upon thermoforming the part, webs that must be removed are created in the corners where you see gaps – highlighted in red – in attached not-that-clear picture.

QC is not happy with those and Daryl insists there are no other way of doing this but modify the mold which will take considerable amount of time and will scrap a few sheets of material during the process.

Note that installers will trim this considerably, more or less the same as what Russ did when installing the panel here for trial install.

Options are:

- Scrap parts and rework mold – a costly solution;
- Stop drill the gap;
- Trim portion of panel same as what was done during DART's trial install to eliminate gap.

What direction do you want Daryl to take?

Marc Bellavance
Technical/Shop Support
DART aerospace Ltd.

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tel: 613-676-0992

fax: 613-632-9311

e-mail: mbellavance@dartaero.com

Web: www.dartaero.com

Product Documentation: Verify Revision Status/Download HERE!



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1/5/2011